

Date: Tuesday, 10/30/2007 2:50:27 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 35455	
Estimate Number : 12530	
P.O. Number : <u>N/A</u>	Part Number : D35471
This Issue : 10/30/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3547
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 32372	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 11/6/2007
Checked & Approved By : <u>[Signature]</u>	Qty: <u>27</u> Um: Each
Comment : Est Rev: A New Issue 06-09-18 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S125	2024-T3 .125 sheet
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1.3368



Comment: Qty.: 0.0557 sf(s)/Unit Total : 0.5565 sf(s)
 2024-T3 .125 Sheet
 (M2024T3S0125)
 Batch: 102087 1B07-11-5

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3547
 Dwg Rev: A 1B 07-11-5
 Prog Rev: A
 ****Ensure Grain Direction is Correct*****

2-Deburr if necessary

[Signature] 27

SAD 07-12-10 27

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



1B07-11-5



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

[Signature] 27 center

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Bend as per Dwg D3557

813 07/12/05 27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 07/12/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/30/2007 2:50:27 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 35455

Part Number: D35471

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counts
07/12/11 (27)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-h 07/12/11

(27)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

27 04-12-11 27x

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-h 07/12/12

(27)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST109

WAS 07/12/12

(27)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/12/13

(27)

Job Completion



W 2007/12/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35455
Description: Bracket		Part Number:	D3547-1
Inspection Dwg: D3547 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

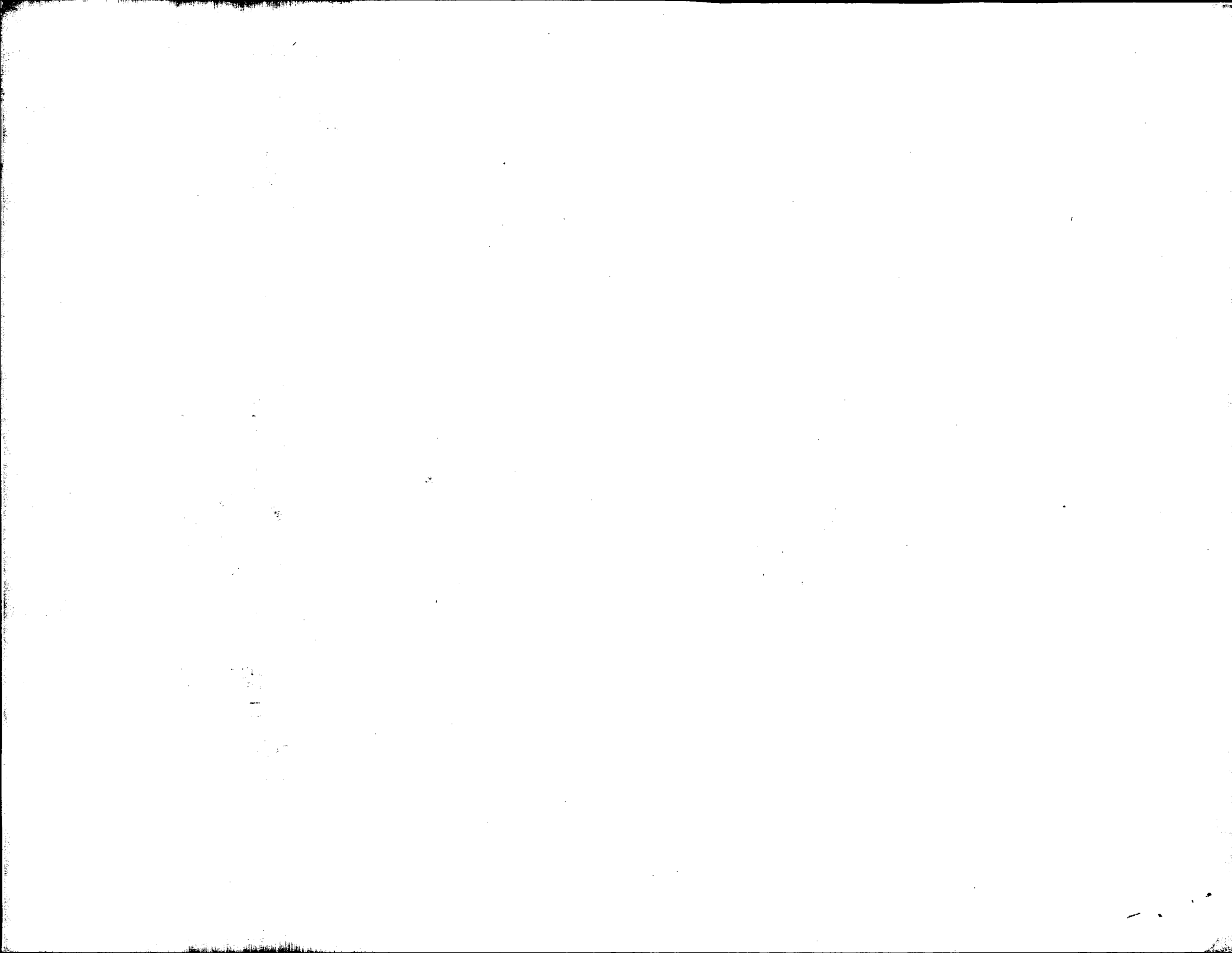
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.313	+/-0.010	.313	X			
0.913	+/-0.010	.913	X			
2.054	+/-0.010	2.054	X			
2.38	+/-0.030	2.37	X			
0.438	+/-0.010	.438	X			
2.813	+/-0.010	2.813	X			
0.575	+/-0.010	.575	X			
1.100	+/-0.010	1.100	X			
1.625	+/-0.010	1.625	X			
2.150	+/-0.010	2.150	X			
2.675	+/-0.010	2.675	X			
3.25	+/-0.030	3.25	X			
Ø0.172	+0.005/-0.001	.174	X			
Ø0.323	+0.006/-0.001	.324	X			
0.125	+/-0.010	.124	X			

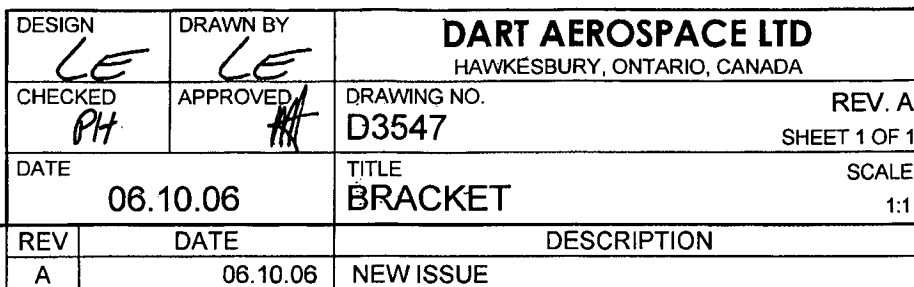
Measured by:	AB
Date:	07-10-5

Audited by:	S
Date:	07/11/06

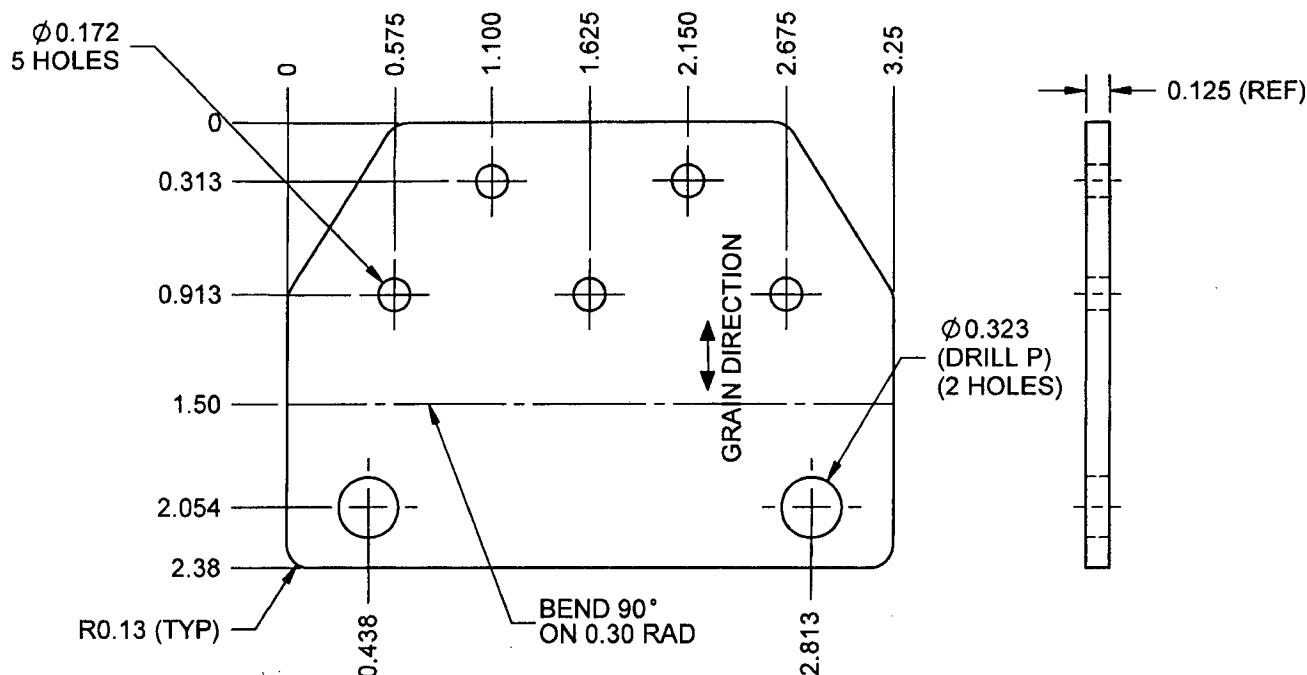
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	BE

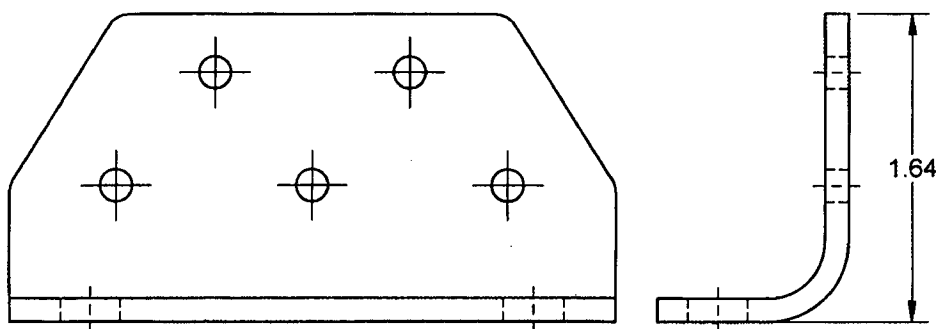




RELEASED
JUN 13 1964

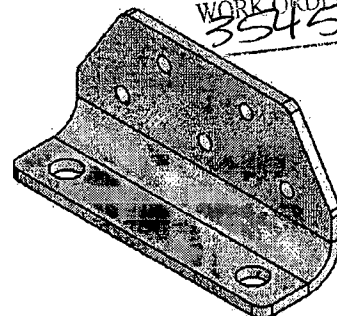


D3547-1F FLAT PATTERN



D3547-1 BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
35455



NOTES:

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER QQ-A-250/11
(REF DART SPEC M6061T6S.125)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
 - 6) IDENTIFY WITH P/N D3547-1 USING FINE POINT PERMANENT INK MARKER

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